

Fig. 1 (a)

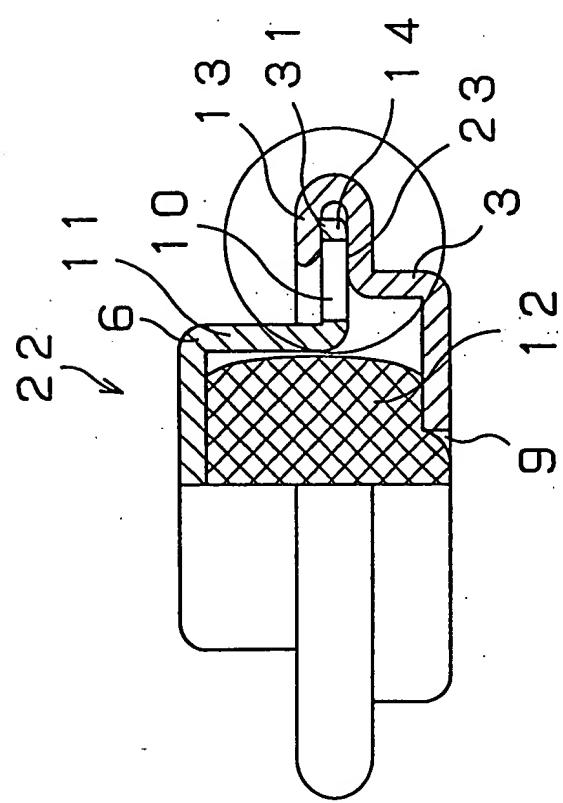
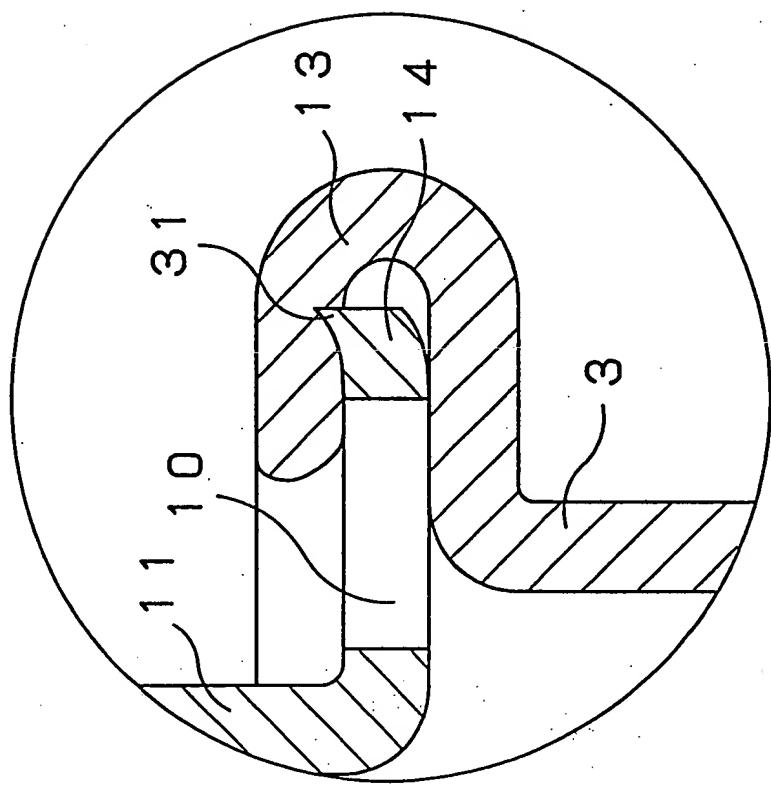


Fig. 1 (b)



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Fig. 2 (a)

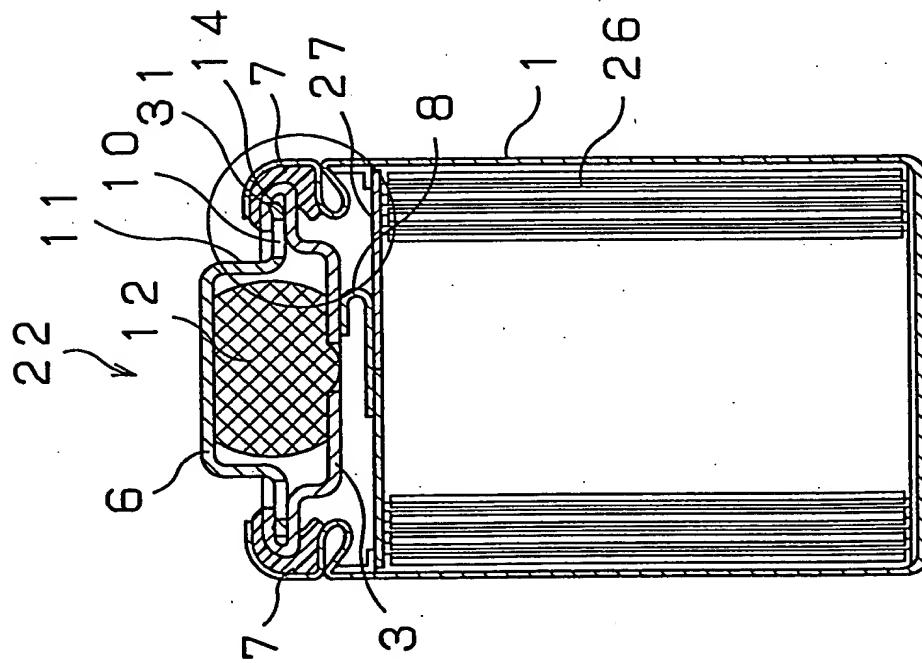
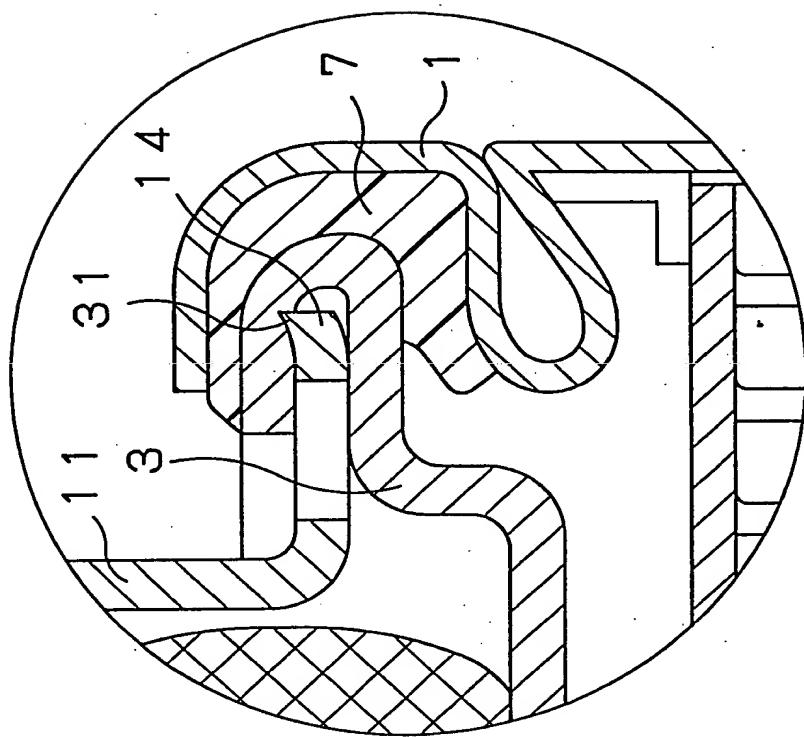


Fig. 2 (b)



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Fig. 3 (a)

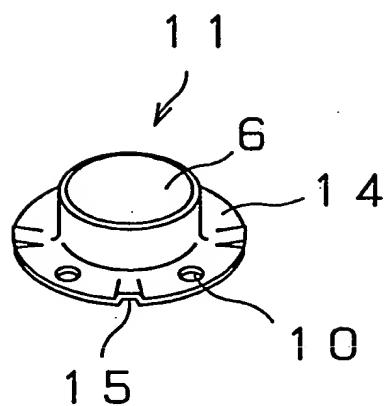


Fig. 3 (b)

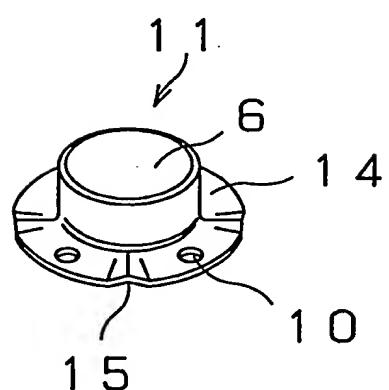


Fig. 3 (c)

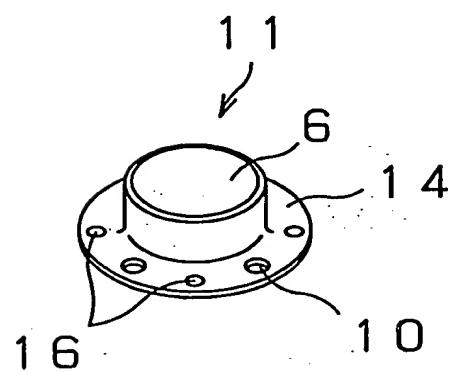
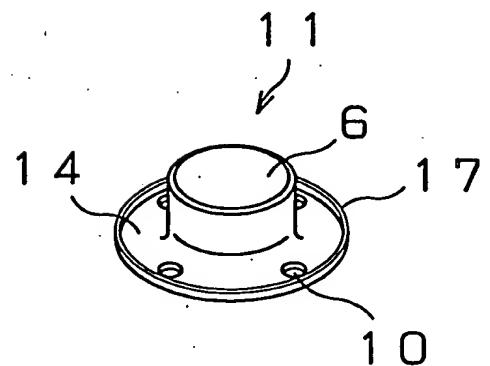


Fig. 3 (d)



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Fig. 4

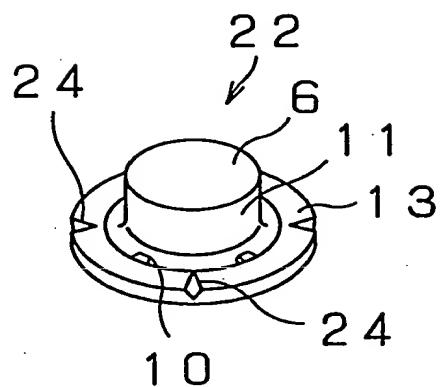
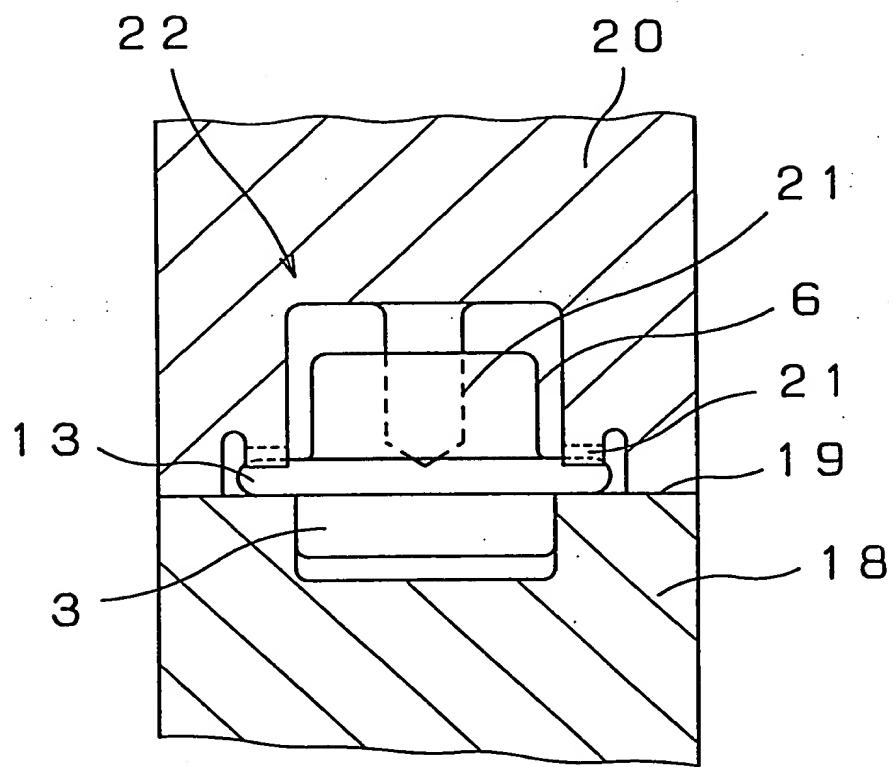


Fig. 5



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Fig. 6 (a)

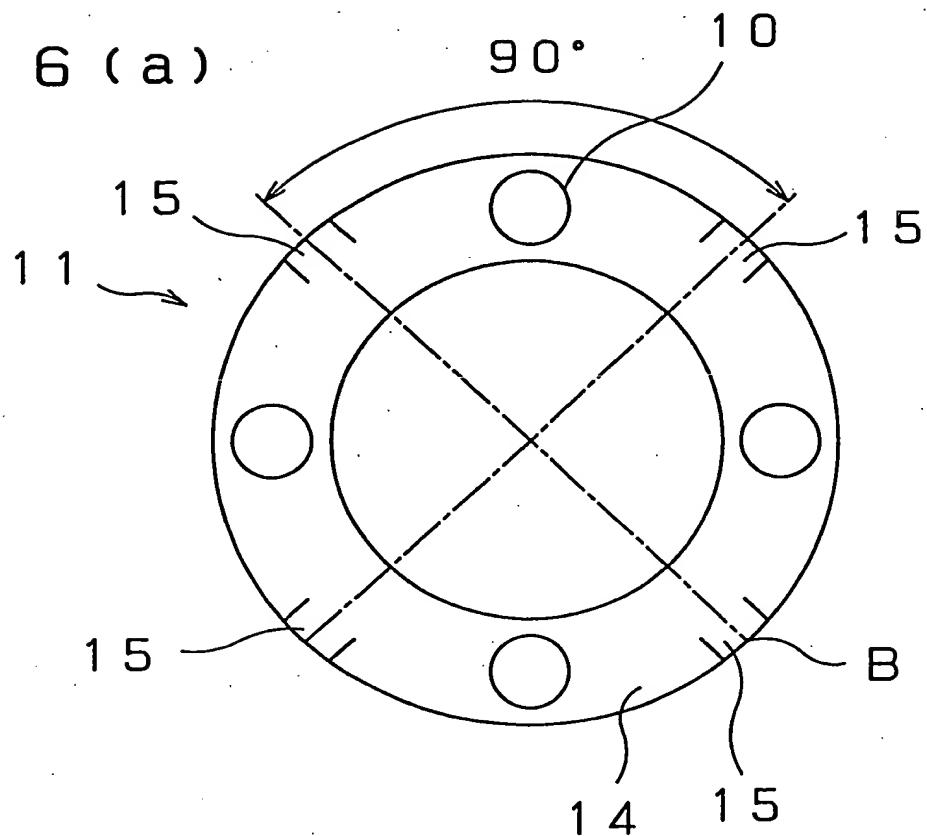


Fig. 6 (b)

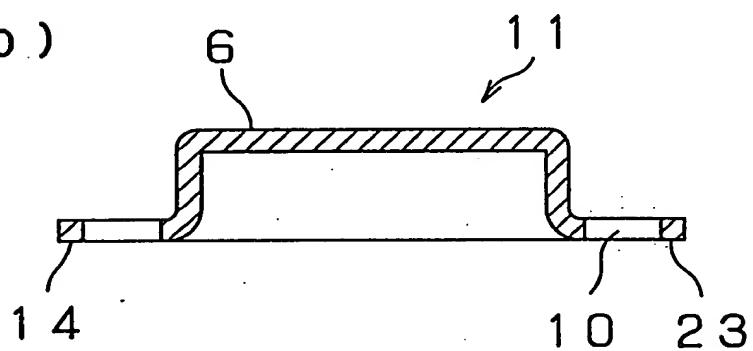
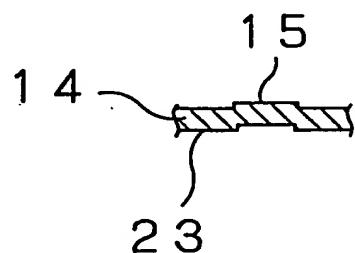
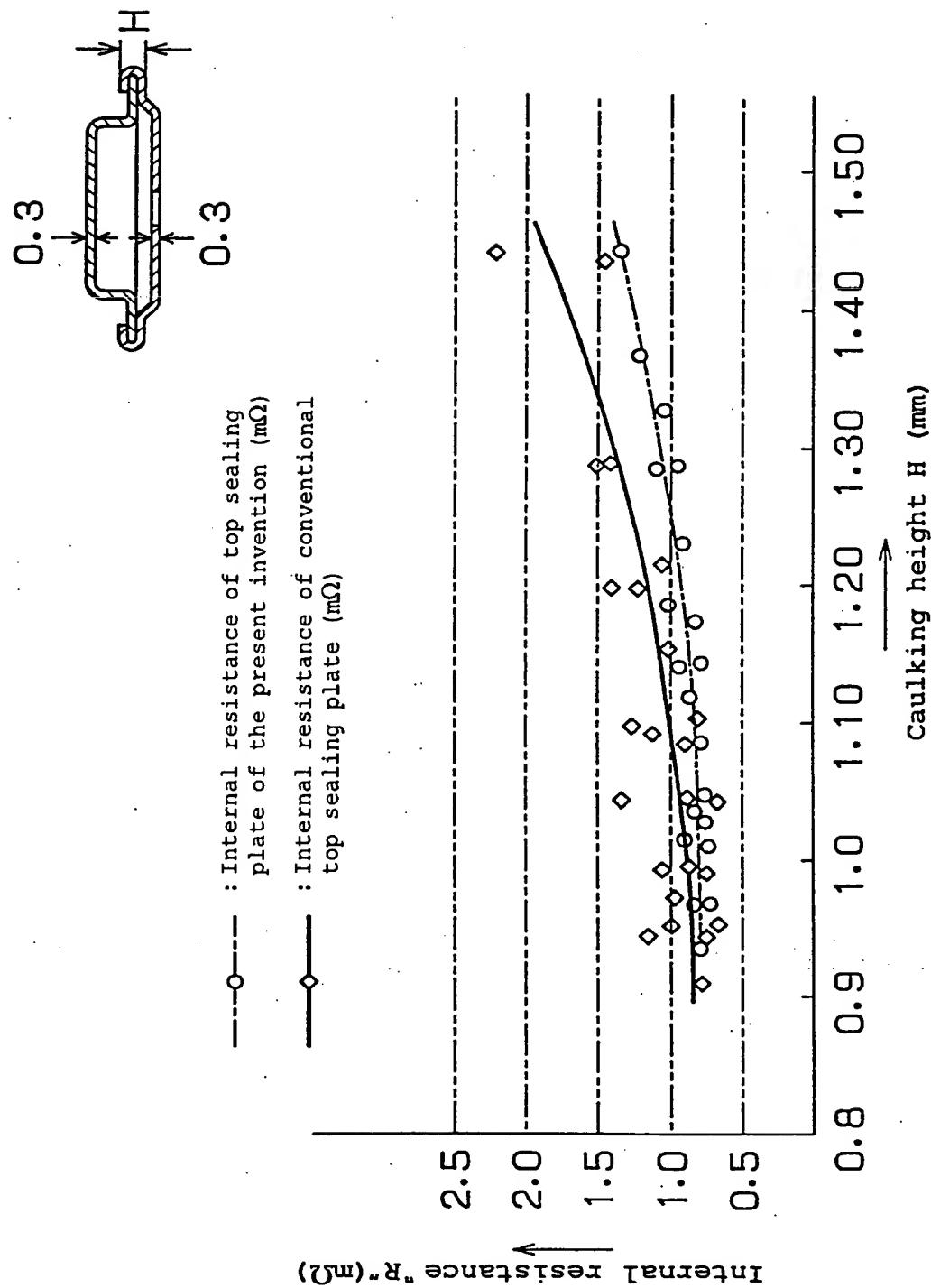


Fig. 6 (c)



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Fig. 7



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Fig. 8

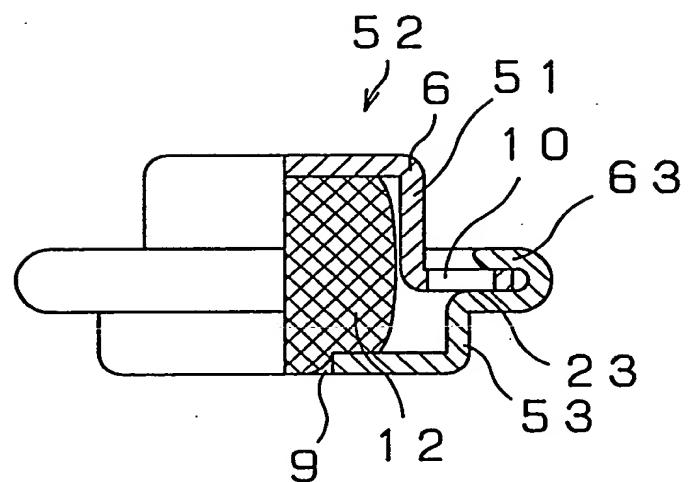
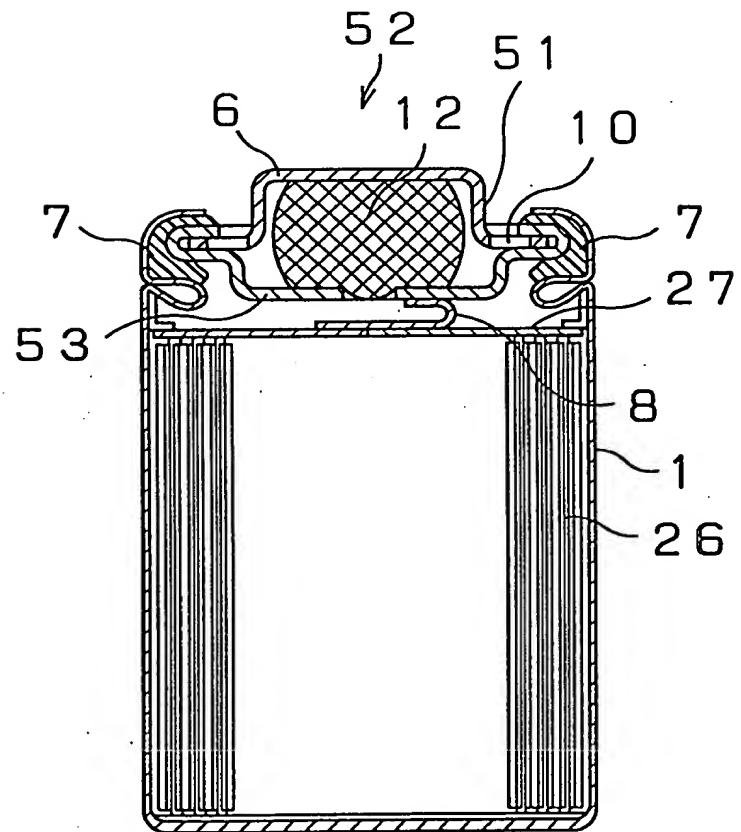


Fig. 9



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Fig. 10

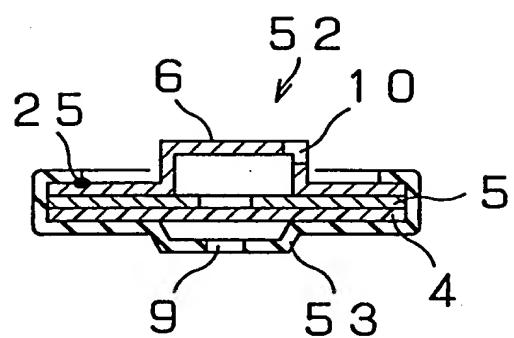


Fig. 11

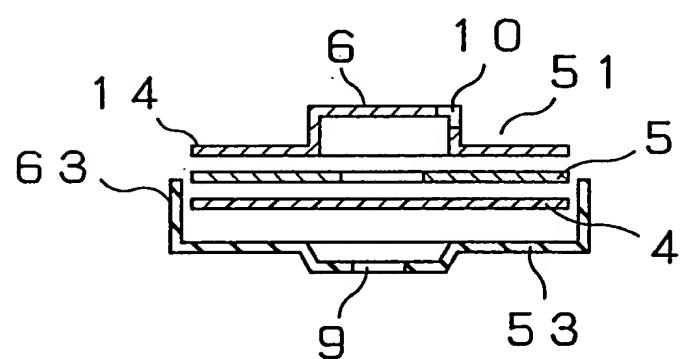
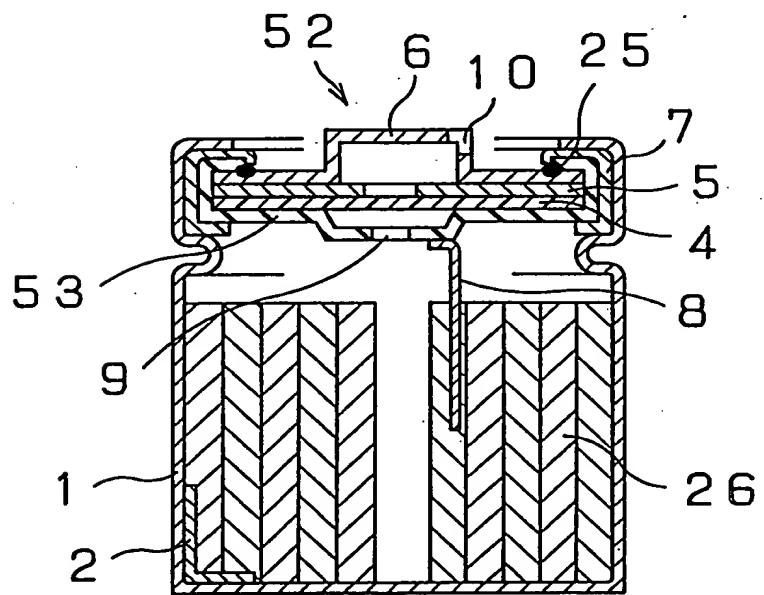


Fig. 12



REFERENCE NUMERALS IN THE DRAWINGS

- 1 Battery case
- 2 Negative lead wire
- 3 Filter (dish-shaped top sealing plate)
- 4 Valve body
- 5 Reinforcement
- 6 Convex portion
- 7 Gasket
- 8 Positive lead plate
- 9 Valve hole
- 10 Gas vent hole
- 11 Cap
- 12 Valve body
- 13 Caulked portion (bend portion of upper opening end of filter, and outer periphery end of flange portion of cap)
- 14 Flange
- 15 Bulge
- 16 Small projection
- 17 Peripheral edge
- 18 Lower press die
- 19 Lower and upper press die abutment
- 20 Upper press die
- 21 Wedge-like portion of press die

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22 Top sealing plate

23 Cap and filter mating face

24 Locally pressurized portion

25 Weld zone

26 Electrodes

27 Collector

31 Projection

H Caulking height

R Internal resistance of top sealing plate